

Stock

Work Order ID 130619

130619

Page 1

Tuesday, March 17, 2015 4:06:38 PM

Item ID: D2174-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Web Assembly
 Start Date: 3/18/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/25/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 15317 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2174	Rev E

100	Small Fab	0.00							
100	Memo	0.00							
Small Fab	1- Assemble as per Dwg D2174-0412- Identify as D2174-041								

4X

15/04/20

DAS
36
9-89

110	QC5- Inspect part completeness to step on W/O	0.00							
110	Memo	0.00							
QC	Quality Control								

(4)

DAS
38
9-89

APR 20 2015

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120	Memo	0.00							
Powdercoat	Powder Coating								
	START TIME: 11:30		OVEN TEMPERATURE:						
	FINISH TIME: 12:00								

40

15-4-21

DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Tuesday, March 17, 2015 4:06:38 PM

130619

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/18/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 3/25/15 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC3- Inspect Part Finish

0.00

130

OC

Memo

0.00

Quality Control

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

Install nuts & bolts loosely as per Dwg D2274

QC5- Inspect part completeness to step on W/O

0.00

150

OC

Memo

0.00

Quality Control

DAG
38
9-89

APR 22 2015

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FAULT CATEGORY

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Start Date: 3/18/15 Start Qty: 2.00 ***2*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST 47A</u>	0.00				<u>5</u>	DAB 27 9-22		
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

APR 22 2015

MLJ 15-04-23

MS. 4-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 130619

130619

Parent Item: D2174-041

D2174-041

Parent Item Name: Web Assembly

Start Date: 3/18/15

Required Date: 3/25/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D04.06.10Reformat; Changed Step 2KJ/JLM
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2174-1 *D2174-1* Web		Manufactured	No			100	Each	4.0000	1	2		15/04/20	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				4					
				107943				4					
D2175-1 *D2175-1* Angle LH		Manufactured	No			100	Each	0.0000	1	2		15/04/20	DAS 36 9-89
D2175-2 *D2175-2* Angle RH		Manufactured	No			100	Each	5.0000	1	2		15/04/20	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				108110				5					

DQA: _____ Date: _____



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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 130619

130619

Parent Item: D2174-041

D2174-041

Parent Item Name: Web Assembly

Start Date: 3/18/15

Required Date: 3/25/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

100

Each

2,012.000

4

8

MS21042L08

Nut

**

15/04/21

DAS
36
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

1000

m131697

1000

ST304

911

123900

16

m128401

156

m130325

15

m131317

500

m131624

224

16

AN526C832R14

Purchased

No

140

Each

121.0000

4

8

AN526C832R14

Screw

**

15/04/20

DAS
36
9-89

Location

Loc Qty

Loc Code

ST327

121

104916

8

124215

105

124916

8

16

MS20470AD4-6

Purchased

No

140

Each

3,305.000

19

38

MS20470AD4-6

RIVET

**

15/04/20

DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

3030

m131618

3030

GA

9

127305

9

ST310

266

m128754

266

76

Tuesday, March 17, 2015 4:06:52 PM

Shop Packet Print

WFB

00000

DQA: _____ Date: _____



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D2174-041

Parent Item Name: Web Assembly

Start Date: 3/18/15

Required Date: 3/25/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN832J

Purchased

No

140

Each

3,054.000

4

8

NAS1149DN832.J

Washer

15/04/21
DAS
36
9.89

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST260a

2500

M131697

2500

ST270

285

124555

15

M131317

270

16

DQA: _____ Date: _____



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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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